

Work Order ID 84384

May-11-12 7:20:10 AM

84384

Page 1

Item ID: D350-591-113

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step, Short

Start Date: 5/11/12 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/17/12 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: U Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2310	D
DSI 9525	A

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D350-591-113 CHG005

4 12.05.17

110

0.00

110

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2244 extrusion to 62.00" long as per Dwg D2310
2-Drill extrusion as per Dwg D2310 using drill Jig DT8230
3-Deburr

4 Ae 12.05.12

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									
130		0.00							
130	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Weld Fwd end cap and bushing as per Dwg D2310 A/R AL ROD Batch: <u>119725</u> 2-Grind end cap and bottom bushing welds flush 3-Machine top weld on bushing flush								
140	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
140									
QC	Memo	0.00							
Quality Control									

5/11/12

74

4

0

12.05.14

12.05.14

4

0

BE12-05-15



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Item ID: D350-591-113 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Step, Short
 Start Date: 5/11/12 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 5/17/12 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160									
HandFinish	Memo	0.00							
Hand Finishing									
170	Large Fab	0.00							
170									
Large Fab	Memo	0.00							
Large Fab	1-Rivet as per Dwg D2310 2-Inspect for foreign object as per QSI 024 3-Weld Aft end cap as per Dwg D2310 A/R AL ROD Batch: <u>119725</u> 4-Grind end cap welds flush <u>120864</u>								

④ VG 12-5-15

4 φ Ae
12.05.15
12.05.15

Ae
12.05.15

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC10- Inspect visual per QSI004- ground welds

0.00

180

QC

Memo

0.00

Quality Control

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

200

Chemical Conversion Coat per QSI005 4.1

0.00

200

HandFinish

Memo

0.00

Hand Finishing

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Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
210									
Powdercoat									
Powder Coating									
	Memo	0.00							
	START TIME: 2:45								
	OVEN TEMPERATURE: 320 OF								
	FINISH TIME: 3:15								
220	Wing Walk as per dwg QSI005 4.4 Batch 101505	0.00							
220									
HandFinish									
Hand Finishing	Memo	0.00							
230	QC3- Inspect Part Finish	0.00							
230									
QC									
Quality Control	Memo	0.00							

4X ☒ 12/05/16

H ☒ 12/05/17

12/01/18

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	Pick Kit	0.00							
240									
Packaging	Memo	0.00							
Packaging									
250	QC4- 100% Inspect kits for completeness	0.00							
250									
QC	Memo	0.00							
Quality Control									
260	PACKAGING RESOURCE #1	0.00							
260									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-591-113								
	Location: _____								

(4) 10/5/17

(4) 10/5/17

(40) 10/5/17

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

270

QC21- Final Inspection - Work Order Release

0.00

270

QC

Memo

0.00

Quality Control

MAY 12/05/13

U1205.17

Picklist Print

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Work Order ID: 84384

Parent Item: D350-591-113

Parent Item Name: Heli-Access-Step, Short

Start Date: 5/11/12

Required Date: 5/17/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:H04.11.09ReformatKJ/JLM
DD verf:EC

IPP Rev:E as per ECN10-586 10.06.18

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2244-116 Step Extrusion		Manufactured	No			110	Each	80.5000	1	4		Ac 12.05.12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		80.5							
				80803		80.5							
D2275 Bushing		Manufactured	No			130	Each	13.0000	1	4		Ac 12.05.14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA015		13							
				72832		13							
D2582 Step Leg Assembly		Manufactured	No			170	Each	15.0000	1	4		Ac 12.05.15	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA014		15							
				72804		8							
				72828		7							
D2673-34 End Plate		Manufactured	No			130	Each	30.0000	2	8		Ac 12.05.15	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		10							
				81468		10							
				WA015		20							
				59690		20							
K591-113 Short Step Instln Kit		Manufactured	No			240	Each	0.0000	1	4		84385 12/5/12	

Picklist Print

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Parent Item Name: Heli-Access-Step, Short

Start Date: 5/11/12

Required Date: 5/17/12

Start Qty: 4.00

Required Qty: 4.00

MS20600-AD4W3

Purchased

No

170

Each

976.0000

16

64

Cherry Rivets

Ac 12.05.15

Location

Loc Qty

Loc Code

ST321

843

111636

36

117601

3

118626

482

120308

322

WA018

133

107939

133

64

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Shop Packet Print

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DART

DESIGN KE	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2310	REV. D SHEET 1 OF 2
DATE 05.11.14		TITLE HIGH SHORT STEP ASSEMBLY	SCALE NTS
A	94.11.10	NEW ISSUE	
B	97.05.22	END CAPS CHANGED	
C	97.07.23	ADDED BUSHING AND FACING INFO	
D	05.11.14	UPDATE FINISHING NOTE	

D2310 HIGH SHORT STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2310	High Short Step Assembly	X
D2244-62.0	STEP EXTRUSION*	1
D2275	BUSHING	1
D2582	STEP LEG ASSEMBLY	1
D2673-34	STEP END PLATE	2
MS20600AD4W3	Rivets	16

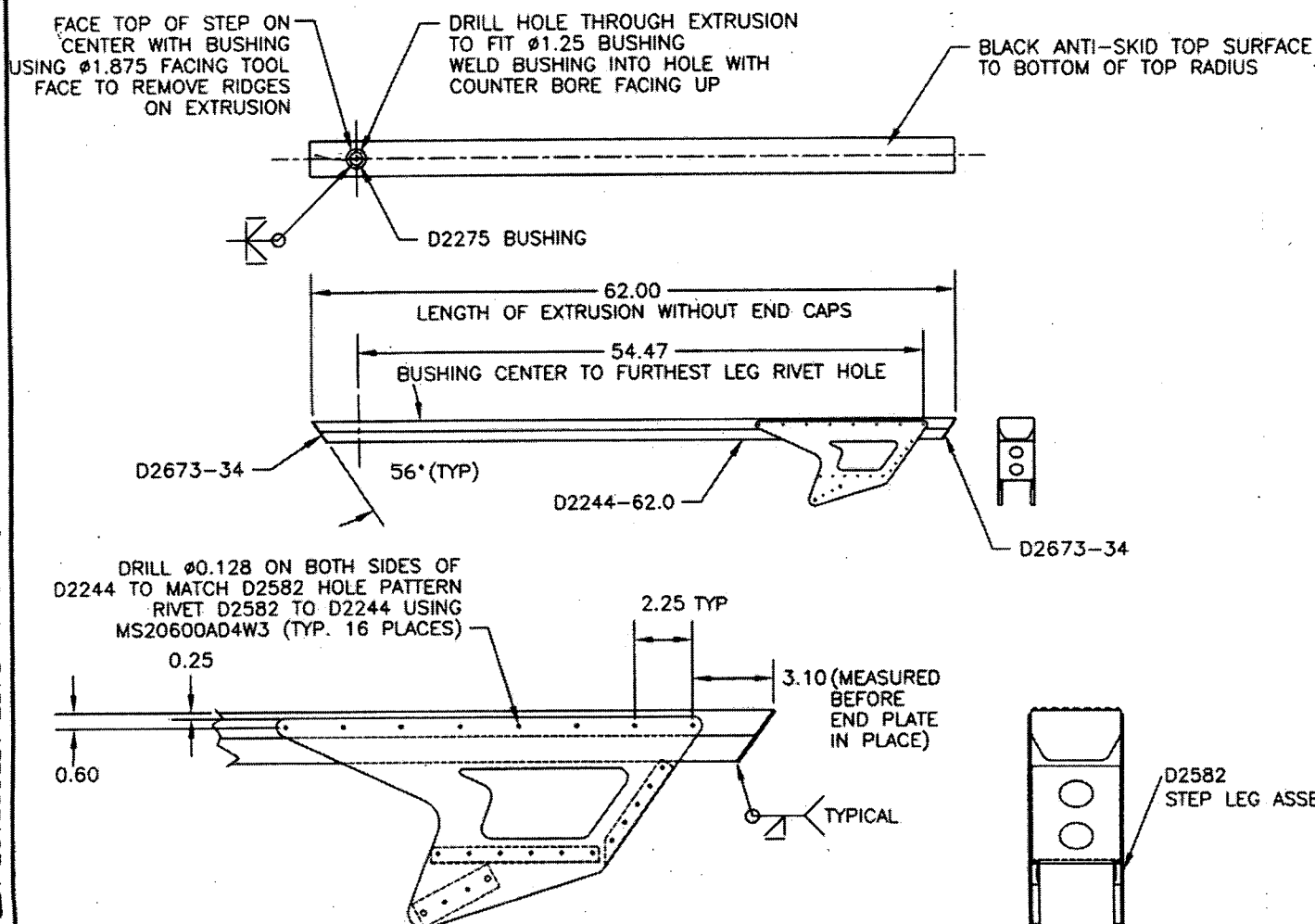
*cut per drawing

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DART

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE LTD
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE	05.11.14	TITLE	D2310	REV. D
				SHEET 2 OF 2
				SCALE
				NTS



STEP LEG DETAIL

D2310 HIGH SHORT STEP ASSEMBLY

- 1) MAKE FROM D2244 STEP EXTRUSION
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05/11/28